

Work Order ID 103710

June-25-13 8:50:12 AM

Rush

103710

Page 1

Item ID: D3296-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Interior Door for -111

Start Date: 6/25/13 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/02/13 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 13-06-25 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3296	B

100 0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

Fabricate & assemble as per Dwg D3296.

Transfer drill using DT8470 & DT9521

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

120

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

120

Powdercoat

Powder Coating

Memo

0.00

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3200F

2:15

ML 23480

2x *13/06/25*

2

2x 13/06/25

Work Order ID 103710

June-25-13 8:50:13 AM

103710

Page 2

Item ID: D3296-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Interior Door for -111

Start Date: 6/25/13 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/02/13 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 QC3- Inspect Part Finish

0.00

130

QC

Memo

0.00

Quality Control

2 0 0 -6-25

140

0.00

140

Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3296

2X 13/06/25

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

Smf
B626

2

Work Order ID 103710

June-25-13 8:50:13 AM

103710

Page 3

Item ID: D3296-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Interior Door for -111

Start Date: 6/25/13 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/02/13 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: _____	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

13/6/26 (2)

13/6/27

13-06-26

Picklist Print

June-25-13 8:50:16 AM

Page 1

Work Order ID: 103710

103710

Parent Item: D3296-041

D3296-041

Parent Item Name: Replacement Interior Door for -111

Start Date: 6/25/13

Required Date: 7/02/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP C05.10.14Added step 14KJ/EC
IPP Rev:D Revised Steps 06-11-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3161-7 *D3161-7* Hinge 14.0"		Manufactured	No			100	Each	4.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST031		4							
				99761		4							
D3161-9 *D3161-9* Hinge 17.0"		Manufactured	No			100	Each	3.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST031		3							
				90221		1							
				95970		1							
				99851		1							
D3296-1 *D3296-1* Door Panel		Manufactured	No			100	Each	3.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		3							
				102977		3							
D3296-3 *D3296-3* Door Panel		Manufactured	No			100	Each	0.0000	1	2			

B102865
(2x)

6/25/13/06/25

6/25/13/06/25

6/25/13/06/25

6/25/13/06/25

Picklist Print

June-25-13 8:50:16 AM

Page 2

Work Order ID: 103710

Parent Item: D3296-041

Parent Item Name: Replacement Interior Door for -111

103710

D3296-041

Start Date: 6/25/13

Required Date: 7/02/13

Start Qty: 2.00

Required Qty: 2.00

MS20470AD4-6

Purchased

No

100

Each

2,952.000

1

2

MS20470AD4-6

RIVET, UNIVERSAL HEAD

**

EB 13/06/25
2

Location

Loc Qty

Loc Code

GA

11

118927

11

ST336

2910

125654

1500

m125807

1410

ST505

31

123021

31

140

Each

19.0000

1

2

**

EB 13/06/25
2

Location

Loc Qty

Loc Code

GA

19

89266

3

90854

6

99733

10

140

Each

17.0000

1

2

**

EB 13/06/25
2

Location

Loc Qty

Loc Code

GA

17

102917

12

99703

5

D2137

Manufactured

No

D2137

Decal(No step)

D2419

Manufactured

No

D2419

Handle

Picklist Print

June-25-13 8:50:17 AM

Page 3

Work Order ID: 103710

Parent Item: D3296-041

Parent Item Name: Replacement Interior Door for -111

103710

D3296-041

Start Date: 6/25/13

Required Date: 7/02/13

Start Qty: 2.00

Required Qty: 2.00

D2462

Manufactured No

140 f

477.3010 2.8166 5.6332

D2462

Seal \$per foot

**

5.6332
6/25/13

Location

Loc Qty

Loc Code

ST403

477.301

48530

13.7336

98802

463.5674

140

Each

-1.0000

0

0

**

5.6332
6/25/13

D2728-1

Manufactured No

D2728-1

Dart Logo label small

MS20470AD4-4

Purchased No

140

Each

5,920.000

25

50

**

50
6/25/13

MS20470AD4-4

Rivet, Universal Head

Location

Loc Qty

Loc Code

GA

1

121652

1

ST336

2891

116188

68

118614

135

122027

188

m125807

2500

ST506

3028

125268

3028

50

Picklist Print

June-25-13 8:50:17 AM

Page 4

Work Order ID: 103710

Parent Item: D3296-041

Parent Item Name: Replacement Interior Door for -111

103710

D3296-041

Start Date: 6/25/13

Required Date: 7/02/13

Start Qty: 2.00

Required Qty: 2.00

NAS1149DN632J

Purchased

No

140

Each

698.0000

1

2

NAS1149DN632.I

Washer

**

JS 6/25/13
2

Location

Loc Qty

Loc Code

ST293

605

123900

5

M126084

600

ST510a

93

125646

93

QTY	PART NUMBER	DESCRIPTION
-041		
X	D3296-041	DOOR ASSEMBLY
1	D2419	HANDLE
2	D2462-0040	SEAL
1	D2462-0053	SEAL
1	D2462-0245	SEAL
1	D2728-1	DECAL
1	D2137	DECAL
1	D3161-7	HINGE
1	D3161-9	HINGE
1	D3296-1	DOOR PANEL
1	D3296-3	DOOR PANEL
1	NAS1149DN632J	WASHER (OR AN960JD6)
25	MS20470AD4-4	RIVET
1	MS20470AD4-6	RIVET

SHOP COPY
 RETURN TO
 ENGINEER
 UNCONTROLLED
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 103710.MCS

130625

RELEASED
 2012-11-21

D3296-041 DOOR ASSEMBLY

D3296-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.8 lbs
- 8) INSTALL D2137 AND D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COATING
- 9) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

B	ADD D3296-041B, REF. PAR12-223.	MB	12.11.15
A	NEW ISSUE	CP	04.06.28
REV.	DESCRIPTION	BY	DATE
DESIGN	99		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.11.15		

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3296
 SHEET 1 OF 3
 TITLE DOOR ASSEMBLY
 SCALE NTS

COPYRIGHT © 2004 BY DART AEROSPACE LTD
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD

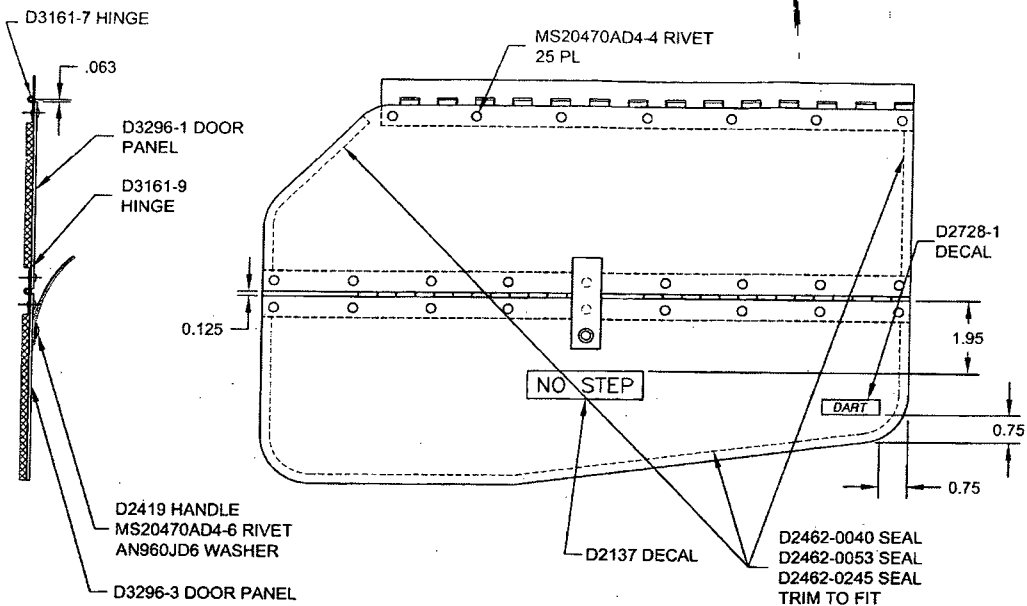
103710

D

C

B

A



D3296-041B DOOR ASSEMBLY, BLANK

D3296-041B NOTES:

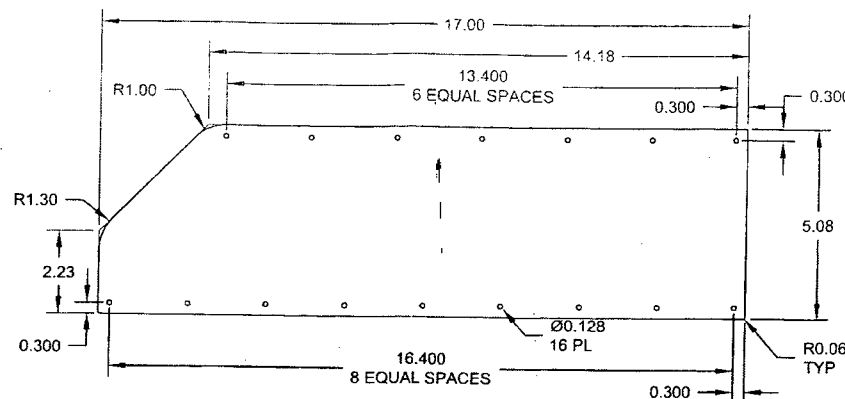
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.8 lbs
- 8) INSTALL D2137 AND D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COATING
- 9) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

QTY -041B	PART NUMBER	DESCRIPTION
X	D3296-041B	DOOR ASSEMBLY
1	D2419	HANDLE
2	D2462-0040	SEAL
1	D2462-0053	SEAL
1	D2462-0245	SEAL
1	D2728-1	DECAL
1	D2137	DECAL
1	D3161-7	HINGE
1	D3161-9	HINGE
1	D3296-1	DOOR PANEL
1	D3296-3	DOOR PANEL
1	NAS1149DN632J	WASHER (OR AN960JD6)
25	MS20470AD4-4	RIVET
1	MS20470AD4-6	RIVET

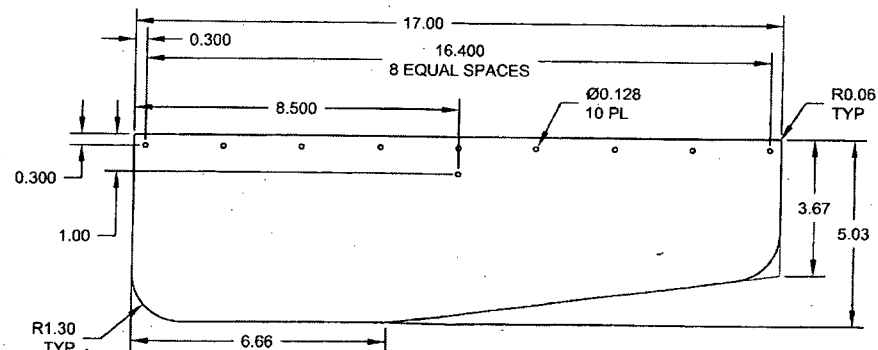
RELEASED
2012-11-21

DESIGN	99	DART AEROSPACE LTD HAWKESSBURY, ONTARIO, CANADA	
DRAWN	JP	DRAWING NO:	REV. 8
CHECKED	JP	D3296	SHEET 2 OF 3
MFG. APPR.	JP	TITLE	SCALE
APPROVED	JP	DOOR ASSEMBLY	NTS
DE APPR.	JP	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
DATE	12.11.15	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

103710



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

RELEASED
2012-11-21
WMO

D3296-1/3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3296-1 = 0.52 lbs; D3296-3 = 0.50 lbs

DESIGN	99	DART AEROSPACE LTD	
DRAWN	J	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. B
MFG. APPR.	J	D3296	SHEET 3 OF 3
APPROVED	J	TITLE	SCALE
DE APPR.	J	DOOR ASSEMBLY	NTS
DATE	12.11.15	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			